

# Work Order ID 85620

**\*85620\***

Page 1

June-12-12 8:51:17 AM

Item ID: D4148-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Stud Receiver, Lower

Stop **\*NS2\***

Start Date: 12/06/2012 Start Qty: 16.00

**\*16\***

Cust Item ID:

Required Date: 26/06/2012 Req'd Qty: 16.00

**\*16\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/12 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4148	d								
100	Cut blanks as per folio	0.00							
<b>*100*</b>									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	5.350" LONG								
110		0.00							
<b>*110*</b>									
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	MACHINE AS PER FOLI FA944 AND DWG FOLIO REV: <u>AA</u> DWG REV: <u>2</u>								
	DEBURR								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

B.A 12/07/01

16

JL 12-07-01

(16)

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 101

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

16

12/07/04 JB

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**\*16\***

Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/7/5 *JD**MF*

12-02-04

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# Picklist Print

June-12-12 8:51:20 AM

Page 1

Work Order ID: 85620

\*85620\*

Parent Item: D4148-3

\*D4148-3\*

Parent Item Name: Stud Receiver, Lower

Start Date: 12/06/2012

Required Date: 26/06/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD IPP  
REV:B 11.03.02 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B1.000X03.000		Purchased	No			100	f	0.4800	0.48	7.68			

\*M303B1 000X03 000\*

\*\*

303 BAR 1" X 3'

Location

Loc Qty

Loc Code

MAT050

0.48

121295

0.48

M122217

7.68

on 12/06/12

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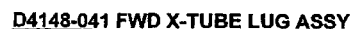
# Dart Aerospace Ltd

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



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85670 M

ORDER  
020 MCT  
12/06/12

ITEM	QTY -X4	P/N	DESCRIPTION
	1	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

RELEASE  
2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D6-3); HOLE DIA CHANGED TO 0.250" (D6-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1 C4-2)	SC	11.02.22
C	REDESIGNED D1418-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (IN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (IN D3-1 & B7-2); 0.129 PL WAS DES 00.129 3 PL (IN D6-3); 0.129 PL WAS 10 PL (IN A7-3); 00.191 WAS 0.129 (IN C8-5). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D1418</b>  REV. <b>1</b> OF <b>1</b>  SCALE <b>FWD X-TUBE LUG ASSY</b> NT	
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
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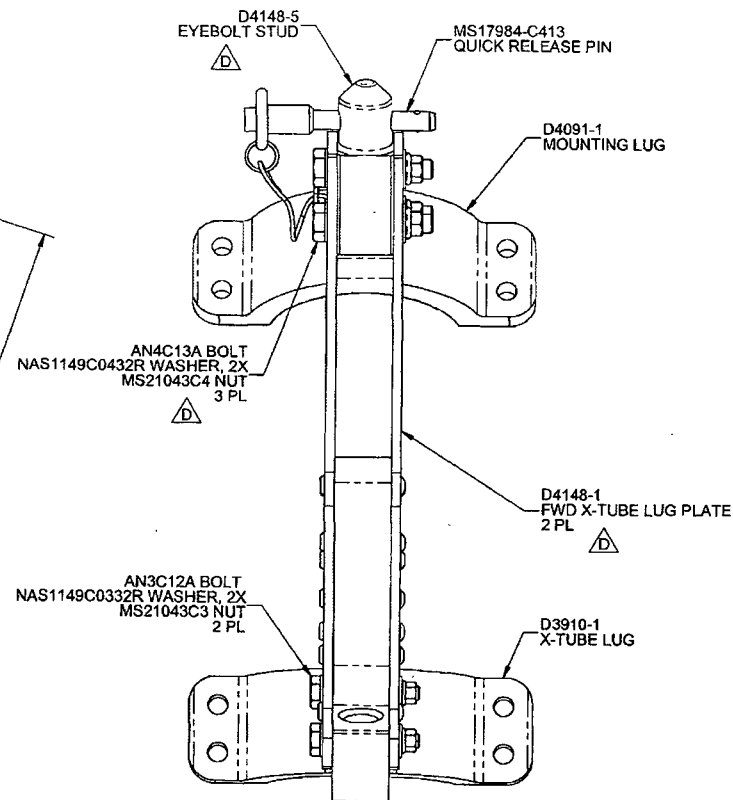
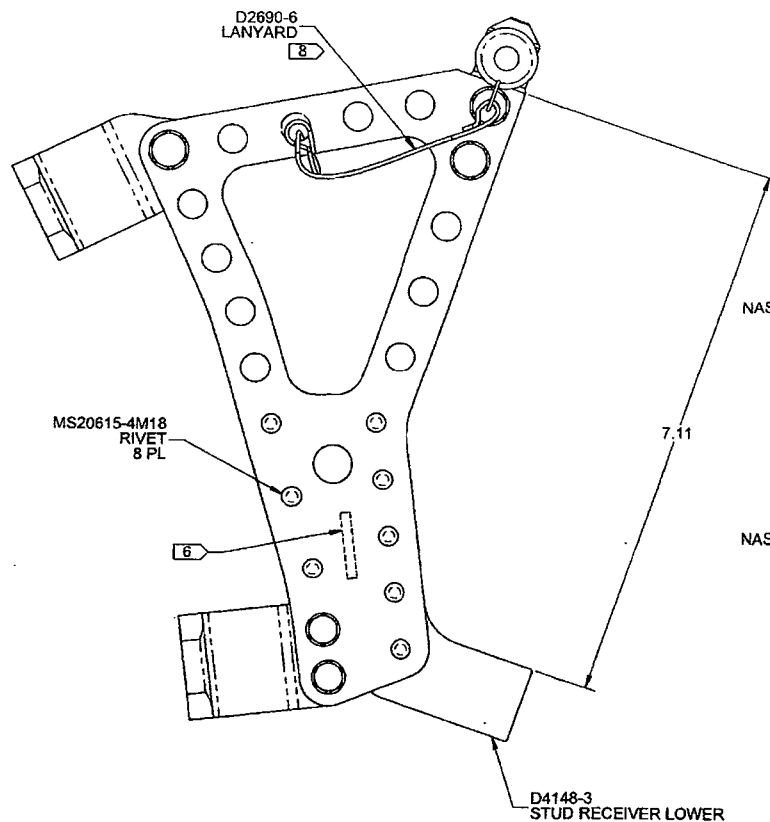
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# **D4148-041 FWD X-TUBE LUG ASSY**

**RELEASED**  
2011-02-24

DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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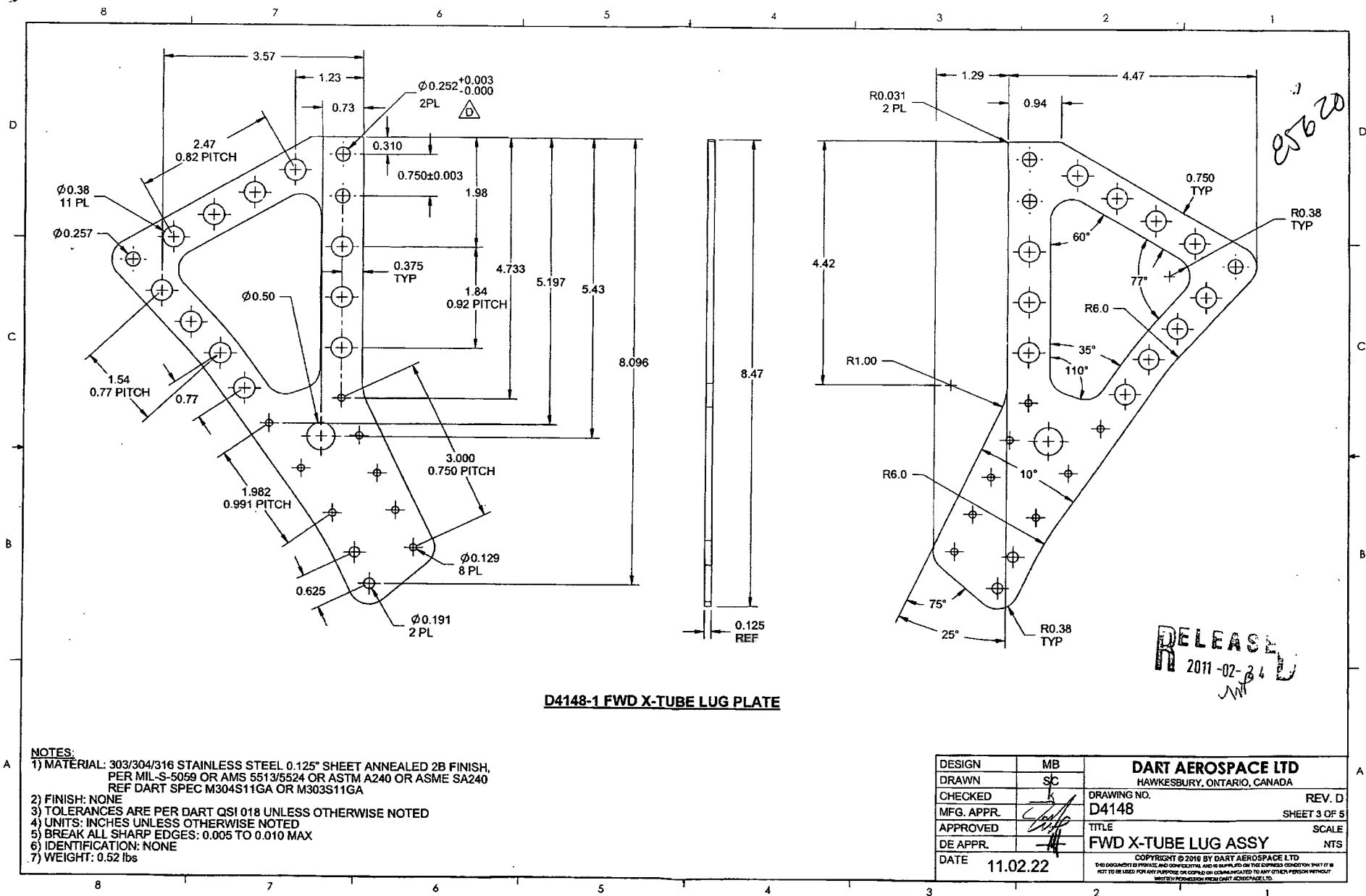
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MFG. APPR.		D4148	SHEET 3 OF 5
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DE APPR.		FWD X-TUBE LUG ASSY	NTS
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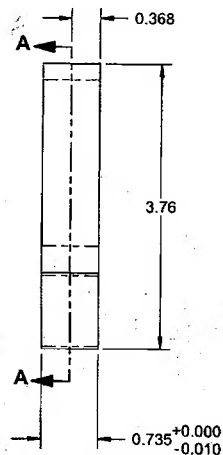
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[illegible]

R0.38  
TYP

RELEASED  
2011-02-24

1) **VALORI:** 1.02 100

DESIGN	MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4148</b>  TITLE <b>FWD X-TUBE LUG ASSY</b>  COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND NOT BE LOANED, REPRODUCED OR COPIED WITHOUT WRITTEN PERMISSION. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMITMENT TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. 1
DRAWN	SC		SHEET 4 OF 4
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DATE	11.02.22		

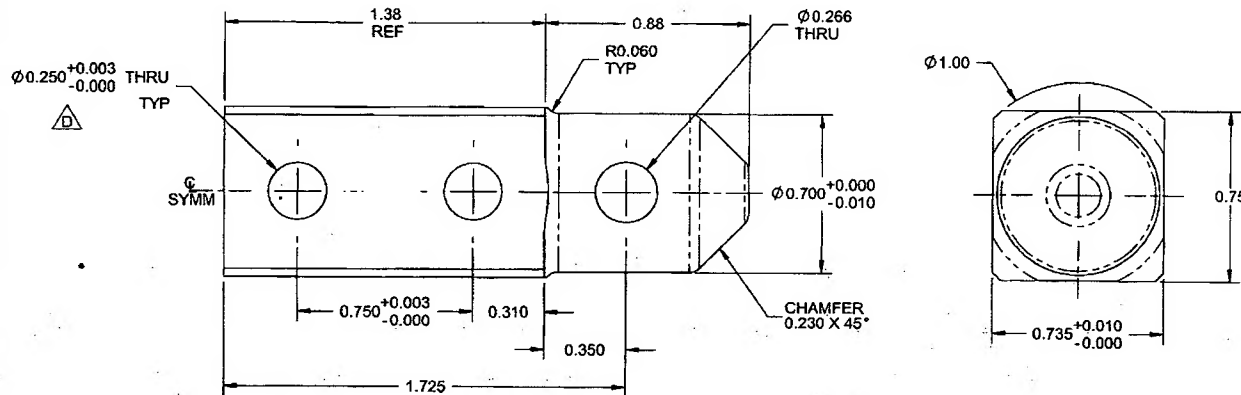
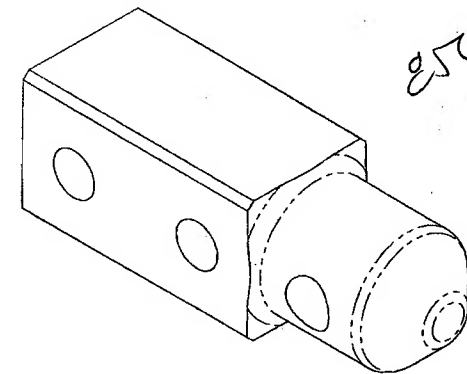
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**D4148-5 EYEBOLT STUD**

**RELEASED**  
2011-02-24  
MP

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

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MFG. APPR.		TITLE <b>FWD X-TUBE LUG ASSY</b>	SHEET 5 OF 5
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